

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-007593**Date Inspected:** 07-Jul-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Xu Xian Ping**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** various OBG subassemblies**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance Inspector (QA) Steve Hall was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island, in Shanghai, China. QA observed and/or found the following:

OBG bay 5

This QA received ZPMC Non Destructive Testing (NDT) notification No. 003619 and performed Ultrasonic Testing (UT) of approximately 10% of the welds previously tested and accepted by ZPMC Quality Control (QC) personnel. This QA generated a UT report for this date. The weld designation is as follows: TR2A-PP014-001.

OBG bay 6

This QA observed ZPMC qualified welding personnel identified as 058174 perform FCAW welding on weld joint identified as CB202G-020-164. ZPMC QC CWI identified as Mr. Lou Chuang Gang was present to monitor the welding process. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2133.

This QA observed ZPMC qualified welding personnel identified as 220061 perform FCAW welding on weld joint identified as CB202G-019-142. ZPMC QC CWI identified as Mr. Lou Chuang Gang was present to monitor the welding process. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2133.

This QA observed ZPMC qualified welding personnel identified as 205774 perform FCAW welding on weld joint identified as FB204-023-021. ZPMC QC CWI identified as Mr. Huang Min was present to monitor the

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welding process. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2132-3.

This QA observed ZPMC qualified welding personnel identified as 062447 perform FCAW welding on weld joint identified as FB204-024-019. ZPMC QC CWI identified as Mr. Huang Min was present to monitor the welding process. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2132-3.

This QA observed ZPMC qualified welding personnel identified as 222396 perform FCAW welding on weld joint identified as FB204-023-044. ZPMC QC CWI identified as Mr. Huang Min was present to monitor the welding process. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2132-3.

OBG bay 7

This QA observed ZPMC personnel fitting and tack welding T-stiffeners to OBG panels identified on the material as SP3022-001, SP3043-001 and BP3023-001.

This QA observed ZPMC qualified welding personnel identified as 051246, 053742 and 054459 perform FCAW welding on weld joints identified as BP3019-001-001~012. The welding process was being performed on Gantry 1 in this bay. ZPMC QC CWI identified as Mr. Zhong Chong Biao was present to monitor the welding process. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2132-3.

Unless otherwise noted, all work observed on this date appeared to be in general compliance with the applicable contract documents.



Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang (15000422372), who represents the Office of Structural Materials for your project.

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Inspected By:	Hall,Steven	Quality Assurance Inspector
Reviewed By:	Prue,Erik	QA Reviewer
